

**Work Order ID 67809**

Thursday, March 31, 2011 8:58:18 AM

Page 1

Item ID: D4373-5

Accept

Revision ID: PRELIM

Item Name: Spacer

Start Date: 3/31/2011 Start Qty: 1.00

Required Date: 4/1/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4373

PA1

100

0.00



Hardinge

Hardinge CNC Lathe Small

Memo

TURN AS PER DWG  
DWG REV: PA1

DEBURR

0.00

J.F.S. 11/03/31

1 0

110

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

J.F.S. 11/03/31

1 0

120

0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

E 11.03.31

1 0

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Required Date: 4/1/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

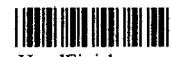
Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

121

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1  $\phi$  11/03/31

122

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 PR 11-3-31

130

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

R0370 mar

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Page 3

Item ID: D4373-5

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Item Name: Spacer

Start Date: 3/31/2011 Start Qty: 1.00

Required Date: 4/1/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 11-03-31 AUTH W

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

*mf*  
*11-03-31*

# Picklist Print

Page 1

Thursday, March 31, 2011 8:58:15 AM

Work Order ID: 67809



Parent Item: D4373-5



Parent Item Name: Spacer

Start Date: 3/31/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV: A NEW ISSUE 11-03-31 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R2.000		Purchased	No				f	49.0000		0.052632			
6061T6 ROUND BAR 2.00													

Location

Loc Qty

Loc Code

MAT013

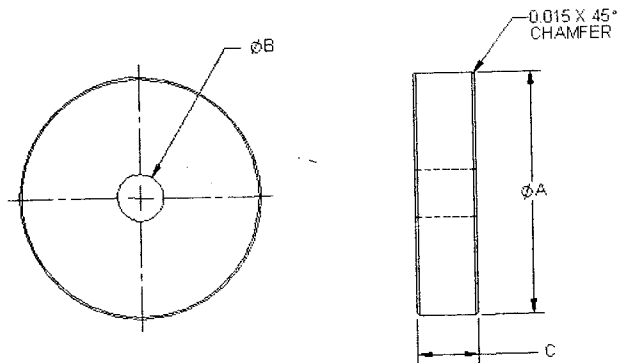
49

17887

49

0.052 4/1/11.03.31





**D4373-Y**

PART NUMBER	ØA	ØB	C
D4373-5	1.625	0.386	0.500
D4373-7	2.000	0.386	0.500

**NOTES**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC. M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.15 lbs

*w/o 67809*

**PRELIMINARY  
ISSUE**

DESIGN	<i>DL</i>	DART AEROSPACE LTD	
DRAWN	<i>DL</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>DL</i>	DRAWING NO.	REV. PA1
MFG. APPR.		<b>D4373</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>FLOOR HARDWARE</b>	NTS
DATE	<b>11.03.29</b>	COPY RIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	